

Date: Wednesday, 01/04/2009 9:10:17 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: NUT PLATE ASSEMBLY		
Job Number	: 46772					
Estimate Number	: 11054					
P.O. Number	:					
This Issue	01/04/2009	S.O. No.	:	Part Number	: D2873045	
Prsht Rev.	: NC			Drawing Number	: D2873 REVA	
First Issue	1 /	Type	MACHINED PARTS	Project Number	: N/A	
Previous Run	: 45210			Drawing Revision	: A	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 09.04.01</u>			Due Date	: 15/04/2009	
Comment	: Est A05.09.13 New issue KJ/JLM			Qty:	20	Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0375X01000	6061T6 BAR .375 x 1.00	
	Comment: Qty.: 0.2363 f(s)/Unit Total : 4.7250 f(s) 6061T6 BAR		
	Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8) (M6061T6B0.375x01.000)		
	Identify for D2873-5		
	Batch: <u>M110829</u> <u>DTP 09/04/03</u>		
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW		
	Cut blanks: 1.000" x 0.375" x 2.700" long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1		
	Machine as per Folio FA and Dwg D2873		
	Identify as D2873-5 Dwg Rev <u>A</u> Folio Rev <u>A</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2873-045 PAR #: N/A Fault Category: Prod / Machine <sup>Part</sup> NCR Yes No DQA: D Date: 09/05/06  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/05/06

NCR: 46772		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/06	3.0	<del>Holes 3/16" off tolerance</del> 3/16" Holes are over tolerance for 2 parts. Incorrect size drill Ø0.333 mounted in collet during Set-up. R.C: Operator set-up error.	QSIU12	2 Pmts scrap Replace qty 2 M 110829	J.F 09/04/06	QSIU12	QSIU12	QSIU12

NOTE: Date & initial all entries

Date: Wednesday, 01/04/2009 9:10:18 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 46772

Part Number: D2873045

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

BB 09/04/06

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

CM01 F1

09/04/07

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

10.0 MS20426AD46

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Rivet

Pick;

Qty Part Number

Description

Batch

4 MS20426AD4-6

Rivet

M105144

BB 09/04/08

11.0 MS21075L5

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut Plate

Pick;

Qty Part Number

Description

Batch

2 MS21075L5

Nut Plate

M110916

212

BB 09/04/08  
M11127 194

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 01/04/2009 9:10:18 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 46772

Part Number: D2873045

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-045

01/04/08 20

13.0 QC5

INSPECT WORK TO CURRENT STEP



09/04/08 20  
counts

Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X tube assy

x20

15.0 QC21

FINAL INSPECTION/W/O RELEASE

09-05-05



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

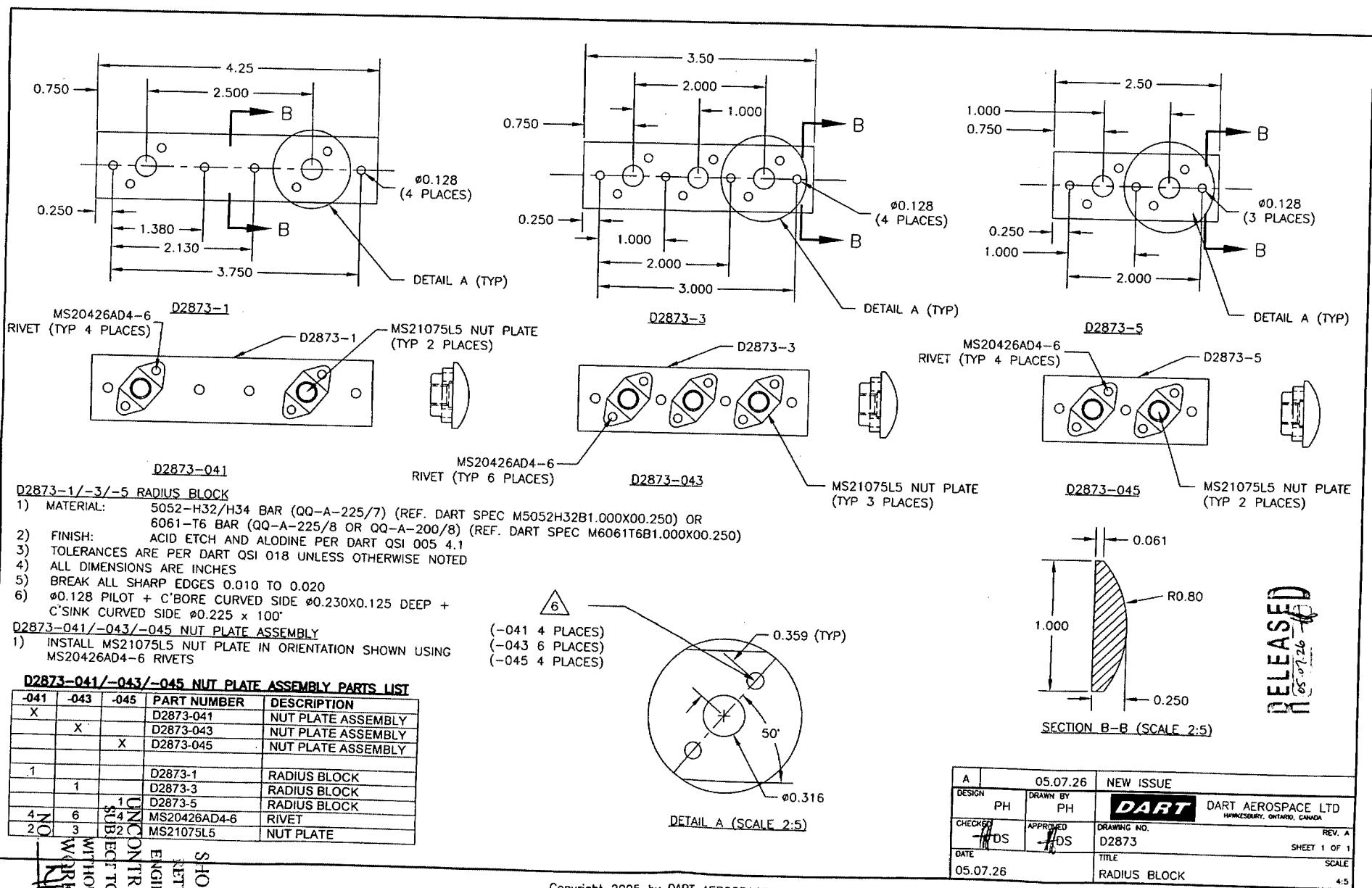
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	140272
Description: Radius Block	Part Number:	D2873-5
Inspection Dwg: D2873	Rev: A	Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## First Article      Prototype

Measured by:	J.F.	Audited by:	<i>SP</i>	Prototype Approval:	N/A
Date:	09/04/04	Date:	09/04/06	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	06.08.30	New Issue	P/O D2873-045	KJ/JLM <i>SP</i>	<i>SP</i>



A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PHOS</i>	APPROVED <i>PHOS</i>	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SCALE 4:5 SHEET 1 OF 1

WORK ORDER NO. 212  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
ENGINEERING  
RETURN TO  
SHOP COPY  
CONTROLLED COPY